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Attorney Docket No. 000004-00682

Amendments to the Abstract:

ABSTRACT

A bending press system provided with a bending press ~~(1)~~ with at least one bending station to mount a plurality of divided tools and, tool housing devices ~~(65, 123)~~ to house divided metals to be used on the bending press and, tool exchange devices ~~(61, 143)~~ which mount ~~said~~ <u>the</u> divided tools on the bending station~~,~~<u>.</u> <u>The system is provided with a first memory</u> ~~in which are provided a first memory means (403)~~ which stores housed positions of each divided tool housed in the housing devices and a second memory ~~means (405)~~ which stores the bending line length of the bent part, the flange length and the bending angle of the bent product and, a first computation ~~means (407)~~ <u>element</u> which, based on the bending line length, flange length, bending angle, computes the tool (cross section shape) type and the length of the bending station, and a second computation ~~means (409)~~ <u>element</u> which, based on the tool type and length of the bending station computes the arrangement of each divided tool on the bending station, and an NC control ~~means (411)~~ <u>device</u> which controls the tool exchange device so that each divided tool is moved from the housed position in the housing device to ~~the~~ <u>a</u> determined arrangement position.